

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013874**Date Inspected:** 08-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and TOWER COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11DW , weld No. SEG071D-009. The welder is identified as #066326. ZPMC QC is identified as Mr. Li Ming Yang . The welding variables recorded by QC appear to comply with WPS-B-P-2213-FCM.

SMAW in the 4G position for the OBG Segment 12AE , weld No. SEG3001AL-024. The welder is identified as #067752. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4G)-REPAIR.

SMAW in the 4G position for the OBG Segment 12CE , weld No. SEG3003N-007. The welder is identified as #067571. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Ultrasonic Testing (UT)

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This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG U-rib to stiffener.

The weld designations reviewed are as follows:

DP3134-001-247,248

DP3134-001-233,234

DP3134-001-265,266

DP3134-001-267,268

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Tower Façade Pad Eye weld. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SL3-43-001

SL3-43-024

SL3-43-025

During Quality Assurance Magnetic Particle Testing (MT) review of welds located on Tower Skin A 43M (W/S) Facade Pad Eye, this Quality Assurance (QA) Inspector discovered the following issues One (1) longitudinal linear indication measuring approximately 10mm in length. The weld is identified as: SL3-43-024. The weld is located at Tower Skin A 43M (W/S) Facade plate. This weld is a Fillet Weld joining the Tower Facade to Pad Eye. This weld is designated as Non Seismic Performance Critical Member (Non SPCM). The Tower Façade is located at Bay #16 Work Shop. The Notice of Witness Inspection Number (NWIT) is 005689. The indication is located outside the area previously tested by ZPMC Quality Control (QC) personnel. The QA Inspector informed to ZPMC QC MR. Yin Chun Fang to make CWR for repair that mention the indication area.

The QA inspector did not generate any incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
